

Date: Thursday, 11/09/2008 10:42:01 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE, INBOARD, RS, 206
Job Number :	41976		
Estimate Number :	10821		
P.O. Number :		Part Number :	D26662
This Issue :	11/09/2008	Drawing Number :	D2666 REV.D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	D
Previous Run :	38752	Material :	
Written By :		Due Date :	10/10/2008
Checked & Approved By :	<u>JLD 08.9.04</u>	Qty:	10
Comment :	Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 7075-T7351 2X6X6.25
 Issue material from stock:
 Cut Size 2.0 x 6.25 X 6.0
 Grain Along Long 6.0 Length

Batch No: B34872

SF 08/09/26 (16)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number.
 1-Inspect part number and batch number are programmed correctly.
 3-Fixturing Inspection last completed on 08/09/27 by ML
 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
 7- Deburr

ML / SF 08/09/26 (16)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

ML 08/09/27 (16)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2666-2 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 08/10/03

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41976</u>		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			
08.09.29	Z	THERE IS A 0.030" x 0.060 CHAMFER ON THE BOTTOM EDGE QTY (2)  0.030 x 0.060 CHAMFER	<u>CP</u> 08.09.29 PC Q5/072	PARTS ACCEPTABLE, NOT IN STRESSED AREA. AREA.	<u>me</u> 08/09/29	<u>S</u> 08/09/29	<u>CP</u> 08.09.29 PC Q5/072	<u>S</u> 08/09/29	

NOTE: Date & initial all entries

Date: Thursday, 11/09/2008 10:42:01 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 41976

Part Number: D26662

Job Number:



Seq. #: Machine Or Operation: Description :

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 08/09/27

(10)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

DIP 08/09/29

(10)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Ft 08/09/30

(10)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*11:00
320°F
11:30*

M-L 08/09/30

(10X)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-09-30

(X10)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57426

Pack 101

9/10/01

(10)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/02

Job Completion



mf 08-10-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41976
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.125	.126	.127	.127		
B	0.100	0.140		.110	.112	.112	.112		
C	2.470	2.510		2.490	2.490	2.490	2.490		
D	0.100	0.180		.135	.135	.135	.135		
E	0.210	0.230		.217	.221	.220	.220		
F	1.313	1.343		1.322	1.322	1.322	1.322		
G	0.240	0.260		.250	.248	.248	.250		
H	0.615	0.685		.660	.660	.660	.660		
I	1.125	1.145		1.134	1.137	1.137	1.138		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.237	.237	.237	.237		
L	0.510	0.515		.512	.512	.512	.512		
M	0.100	0.120		.110	.110	.110	.110		
N	1.565	1.585		1.570	1.571	1.571	1.570		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.500	.500	.501		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.499	2.500	2.500	2.500		
U	1.357	1.367		1.360	1.362	1.361	1.361		
V	0.315	0.322		.321	.321	.321	.321		
W	0.540	0.560		.547	.549	.550	.550		
X	1.674	1.684		1.676	1.678	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>mf</i>
Date: 08/09/27

Audited by: <i>DJP</i>
Date: 08/09/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 41976
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.124	.122	.125	.126		
B	0.100	0.140		.112	.112	.112	.112		
C	2.470	2.510		2.490	2.490	2.490	2.490		
D	0.100	0.180		.135	.135	.137	.138		
E	0.210	0.230		.219	.221	.221	.221		
F	1.313	1.343		1.322	1.322	1.322	1.322		
G	0.240	0.260		.249	.247	.247	.248		
H	0.615	0.685		.660	.666	.660	.660		
I	1.125	1.145		1.137	1.137	1.136	1.137		
J	0.990	1.010		1.000	1.000	.999	1.000		
K	0.235	0.240		.238	.238	.238	.238		
L	0.510	0.515		.511	.510	.511	.510		
M	0.100	0.120		.110	.112	.112	.110		
N	1.565	1.585		1.570	1.570	1.570	1.570		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.500	.504	.500		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.321	.321	.321	.321		
W	0.540	0.560		.550	.556	.550	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>aml</i>
Date: 08/09/27

Audited by: <i>DJP</i>
Date: 08/09/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order: 41976
Description: 206 Saddle, Inboard, Right side		Part Number: D2666-2
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.126	.126				
B	0.100	0.140		.112	.112				
C	2.470	2.510		2.490	2.490				
D	0.100	0.180		.138	.138				
E	0.210	0.230		.221	.221				
F	1.313	1.343		1.322	1.322				
G	0.240	0.260		.249	.248				
H	0.615	0.685		.660	.660				
I	1.125	1.145		1.136	1.136				
J	0.990	1.010		1.000	1.000				
K	0.235	0.240		.238	.238				
L	0.510	0.515		.510	.511				
M	0.100	0.120		.110	.110				
N	1.565	1.585		1.569	1.569				
O	5.990	6.010		6.000	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.490	0.510		.503	.501				
S	0.313	0.318		.318	.318				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.315	0.322		.321	.321				
W	0.540	0.560		.550	.551				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.259	.259				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

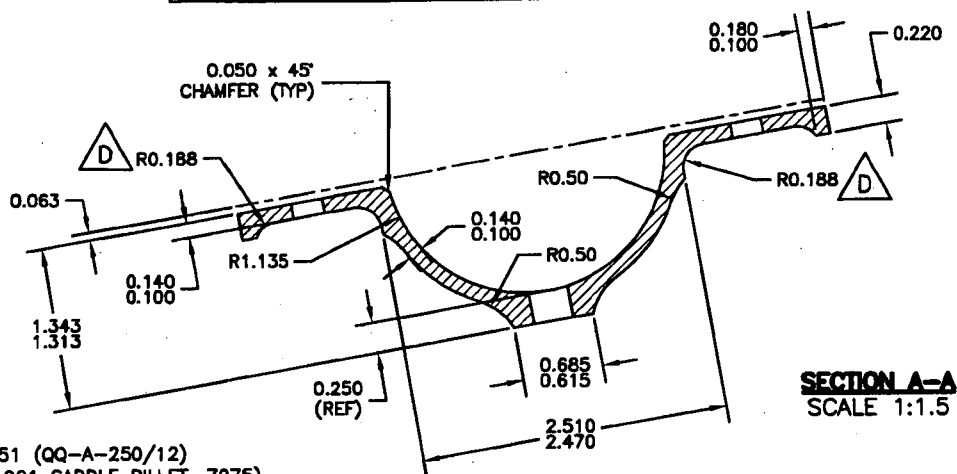
Measured by: <i>ml</i>	Audited by: <i>DSP</i>
Date: 08/09/28	Date: 08/09/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



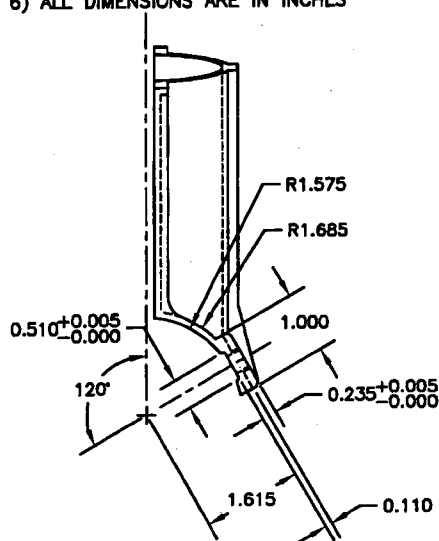
DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

RELEASED
07.02.12 *PH*

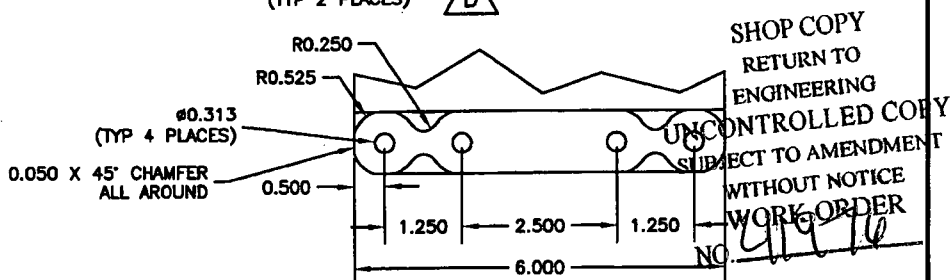
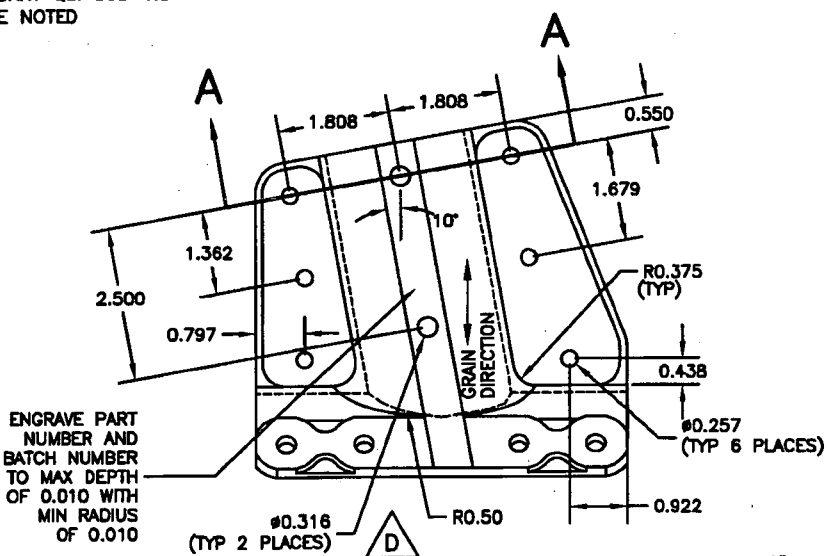


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH



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